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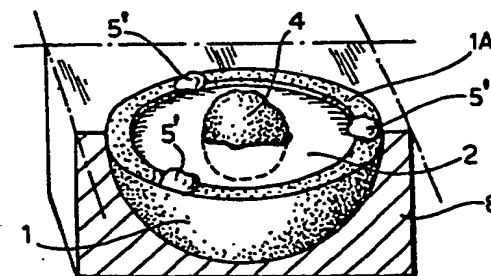
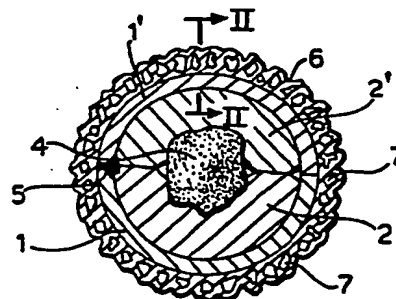
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(71) Applicant: **Ferrero S.p.A., Piazzale Pietro Ferrero 1, I-12051 Alba (Cuneo) (IT)**(43) Date of publication of application: 24.08.83
Bulletin 83/34(72) Inventor: **Ciliario, Lorenzo, Via F.lli Bandiera 3, I-12051 Alba (Cuneo) (IT)**(84) Designated Contracting States: **BE DE FR GB LU NL**(74) Representative: **Bosotti, Luciano et al, c/o Jacobacci-Casetta & Perani S.p.A. Via Alfieri, 17, I-10121 Torino (IT)**(54) **Filled sweets with wafer shell and process for their production.**

(57) The product comprises a filling (2, 2') contained by two concave half-shells (1, 1') of wafer which together form a shell with a closed cavity, and is coated with chocolate (6). The filling (2, 2') has a creamy consistency, a water content of not more than 2% by weight, and is in direct contact with the half-shells. The mating edges (1A) of the half-shells (1, 1') are joined together at points or continuously by means of a deposit (5) of molten chocolate which is normally solid. Preferably, the chocolate coating (6) contains granules (7) or flakes of hazelnut, walnut, coconut, almonds or the like. Typically, the product has a substantially spherical shape with a diameter of the order of 2.5 to 3 cms.



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TITLE MODIFIED

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"Filling-containing pastry product and method of making same".

The present invention relates to a confectionery product which comprises a filling contained by two wafer half-shells which together form a shell with a closed cavity, and is coated with chocolate.

5 In known products of this type, which are the form of a small bar, the filling has a consistency such that, at ambient temperature (18 to 20°C), it is pasty to semi-hard or hard and serves to join the two half-shells together not only in the finished product but
10 also, and above all, before and during the enrobing with chocolate. On being eaten, these products stick in the mouth and therefore are not generally so enjoyable.

Thus, the object of the present invention is to provide a product of the aforesaid type which is crunchy
15 and at the same time pleasantly "fluid" in the mouth. Further objects and advantages will become evident from the following description.

The confectionery product according to the invention, which has a filling contained by two concave
20 wafer half-shells together forming a shell with a closed cavity, and is coated with chocolate, is characterised essentially in that the mating edges of the two half-shells are joined together at points or continuously by a deposit of molten chocolate which is normally solid,
25 the filling having a creamy consistency at ambient temperature, having a water content of not more than 2% by weight, and being in direct contact with the half-shells.

The term "creamy consistency" used here means that the filling would not keep its own shape indefinitely without being confined with the shell, unlike the "pasty consistency". The filling is given this consistency by a suitable percentage of one or more vegetable oils.

Preferably, the product according to the invention is of substantially spherical shape and has a diameter of the order of 2.5 to 3 cms so that it can be eaten in a single mouthful. Furthermore, the chocolate coating may be made more interesting from the aspects of both appearance and flavour by the incorporation therein of pieces (granules) or flakes of certain natural products, such as hazelnuts, walnuts, coconut, almonds and the like. Moreover, a solid edible centre, for example, a nut or a small candied fruit, may be put in the centre of the filling.

In the appended drawings:

Figure 1 is an axial section of a product of spherical shape;

Figure 2 is a partial section taken on the line II-II of Figure 1, and

Figure 3 is a partial perspective view illustrating the product in a stage of manufacture.

The product illustrated comprises two hemispherical half-shells 1, 1' of wafer, the edges of which mate in the equatorial plane to form a closed spherical shell. Before closure, a mass of creamy filling 2, 2' is deposited in each of the two half-shells. Generally, the two masses 2, 2' are of identical composition, but

they may have different compositions. However, together they form a single filling in the centre of which is shown a hazelnut 4. The two half-shells are joined together by discrete deposits 5 of molten chocolate which is normally solid. In the chocolate coating 6 are incorporated pieces 7 of hazelnut. The thicknesses of the coating 6 and the half-shells 1, 1' are exaggerated in the illustration for clarity of representation.

The masses of filling 2, 2' may, for example, have the following composition by weight:

sugar	40 - 50%
hazelnut paste	10 - 15%
cocoa	about 5%
powdered milk	2 - 10%
vegetable oil	30 - 40%
soya lecithin and flavouring	q.s.

The ingredients are ground together until a homogeneous semi-fluid cream is obtained.

In the manufacturing process, arrays of half-shells 1 are placed in corresponding cells of a plate-shaped mould and identical arrays of half-shells 1' are placed in another plate mould. Figure 3 illustrated a half-shell 1 in its mould 8. The half-shells are then filled with their respective masses of filling, for example, by means of volumetric metering, and the hazelnuts 4 are inserted in the half-shells in one of the moulds. Subsequently, spots 5' of molten chocolate which serve as the joining material are deposited at evenly spaced points around the circular edges 1A of the

half-shells in one of the moulds (half-shell 1 in Figure 3), after which the two moulds are closed like a book in register with each other so that the spots 5' are squeezed between the mating edges of the respective
5 half-shells to effect joining. If desired, a continuous ring of molten chocolate may be deposited on the edge 1A instead of the spots 5' so as to form a continuous join rather than points of joining.

In the stage immediately after the manufacturing
10 process, the two moulds which are closed like a book are cooled to below ambient temperature, typically to about 10°C, to set the join and thicken the consistency of the filling 2, 2', after which the moulds are opened and the half-products in the form of closed wafer
15 spheres are taken from the moulds and subsequently moved on to be quickly enrobed with molten chocolate and then immediately sprinkled with granules of hazelnut or the like. There is thus obtained on each sphere a first coating layer of chocolate, indicated 6A in Figure 2, in
20 which granules 7 of hazelnut are fixed. In order to set this coating, a brief cooling in a current of air is necessary after which a final enrobing with molten chocolate is carried out to form a second coating layer 6B which covers the granules 7 (Figure 2). The two
25 layers 6A, 6B together form the coating indicated 6 in Figure 1. After a final cooling, for example, at 10°C, the product is passed on for packaging.

The product according to the invention can be kept for several months at a temperature which, of
30 course, does not cause melting or unacceptable softening

of the coating 6. The wafer shell 1, 1' always stays crisp and, because of this and the fluidity of the filling 2, 2', results in a pleasant palatability for the consumer. With regard to the industrial manufacturing process, in particular the stages of removal from the moulds and enrobing, the two half-shells stay securely joined together in their initial register with each other, by virtue of the three or four points 5 of joining. Their consistency is not prejudiced in the enrobing stage mainly because the wafer shell has an insulating effect against the heat of the molten enrobing chocolate.

CLAIMS:

1. Confectionery product which comprises a filling contained by two wafer half-shells together forming a shell with a closed cavity and is coated with chocolate, characterised in that the mating edges of the two half-shells are joined together at points or continuously by a deposit of chocolate which is normally solid, the filling having a creamy consistency at ambient temperature, having a water content of not more than 2% by weight, and being in direct contact with the half-shells.
2. Product according to Claim 1, having a substantially spherical shape, preferably with a diameter of the order of 2.5 to 3 cms.
3. Product according to Claim 1 or Claim 2, in which the chocolate coating includes pieces or flakes of hazelnuts, walnuts, coconut, almonds or the like.
4. Product according to Claim 1, 2 or 3, in which the filling encloses a solid edible centre, preferably a hazelnut or candied fruit.
5. Product according to 1 to 4 and substantially as described with reference to the appended drawings.
6. Process for the manufacture of the product according to any one of the preceding claims, in which, before enrobing, the edges of the two half-shells are joined together by the interpositioning of molten chocolate which is normally solid.
7. Process according to Claim 6, in which the half-product to be enrobed, comprising the two united half-shells, is cooled to below ambient temperature preferably to about 10°C.

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8. Process according to Claims 6 and 7 and substantially as described.

FIG. 1

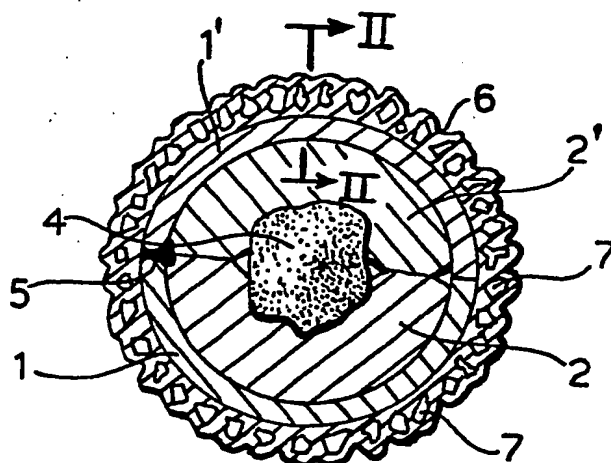


FIG. 2

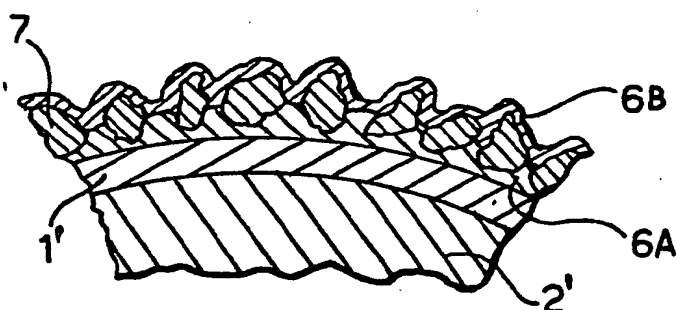
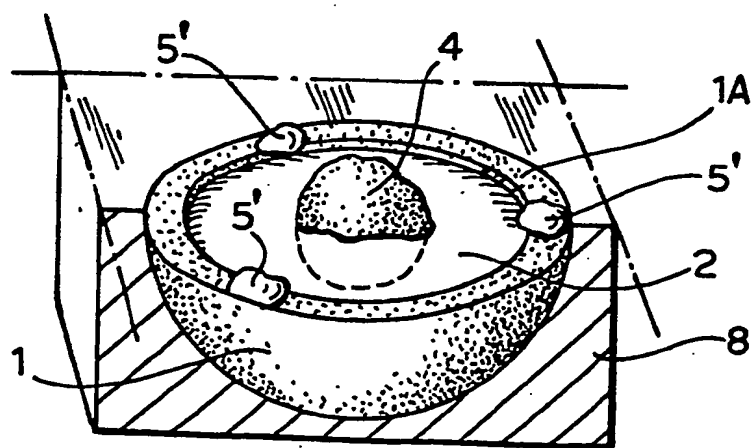


FIG. 3



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(72) Inventor: Cillario, Lorenzo, Via F.lli Bandiera 3, I-12051 Alba (Cuneo) (IT)

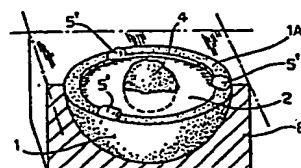
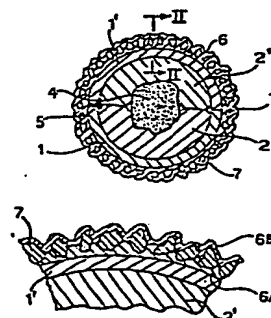
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EUROPEAN SEARCH REPORT

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DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 3)
Y	CH-A- 521 718 (P. BULLIARD) * Figures 2,3; page 1, column 1, lines 25-31; claim 1, under-claim 1-3; column 3, line 6 - column 4, line 10 *	1-3,5	A 23 G 3/20 A 23 G 3/00

X	FR-A-2 254 279 (R. VIRETTO) * Figures 1-3; claims 1,3,4; page 3; page 2, lines 1-10, 18-25 *	1,2,5	

Y	FR-A-1 203 203 (C. PAULET) * Figures 1-5; abstracts 2 ^{Ob} , 2 ^{Oc} ; page 1 *	1-3,5	
A		4,6,8	TECHNICAL FIELDS SEARCHED (Int. Cl. 3) A 23 G

X	US-A-1 809 383 (A. HEYBOER) * Pages 1,2 *	1-8	

X	US-A-1 383 290 (J.A. CRESSEY) * Pages 1,2; figures 1-4 *	1-8	

A	US-A-1 382 601 (J.A. CRESSEY) ---		

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The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 09-01-1985	Examiner GUYON R.H.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	

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DOCUMENTS CONSIDERED TO BE RELEVANT			CLASSIFICATION OF THE APPLICATION (Int. Cl.)
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	
A	FR-A- 463 832 (J.M.A. BRMAULD DES HOULIERES et al.) ---		
A	FR-A-2 285 078 (K. GIEBELEN) ---		
A	GB-A- 416 970 (GEO. BASSETT & COMPANY) ---		
A	US-A-3 574 639 (J.H. FORKNER) ---		TECHNICAL FIELDS SEARCHED (Int. Cl.)
A	FR-A-2 472 346 (P. FERRERO) ---		
A	DE-B-1 169 270 (H.G. MONHEIM) -----		